

Date: Monday, 11/6/2006 2:40:23 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG
Job Number : 29351
Estimate Number : 11065
P.O. Number : N/A Part Number : D2944
This Issue : 11/6/2006 S.O. No. : N/A Drawing Number : D2944 REV A
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A
Previous Run : 27971 Material : N/A
Written By : Due Date : 11/15/2006 Qty: 20 Um: Each
Checked & Approved By : 06/11/07 21
Comment : Est B 04.01.21 Reformat; Added Step 6 KJ/RF
Est. C 06.07.21 waterjet EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0187X04000 6061-T6 Bar .178" x 4.0"



Comment: Qty.: 0.2581 f(s)/Unit Total: 5.1618 f(s) 5.4199
6061-T6 Bar .178" x 4.0"
Material: 6061-T6 (QQ-A-250/11) 0.188" thick
Identify for D2944 X Batch: M19881 ml 06 11 08 (21)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D2944
Dwg Rev: A
Prog Rev: A

ml 06 11 08

(21)

2-Deburr if necessary

540 06/11/12

(21)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



ml 06 11 08



(21)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Counted
06/11/08 (21)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 57396

06/11/13 (21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes NO DQA: DD Date: 06/11/15

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(21)

Comment: FINAL INSPECTION/W/O RELEASE

SP 06/11/15

Job Completion



u 06.11.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

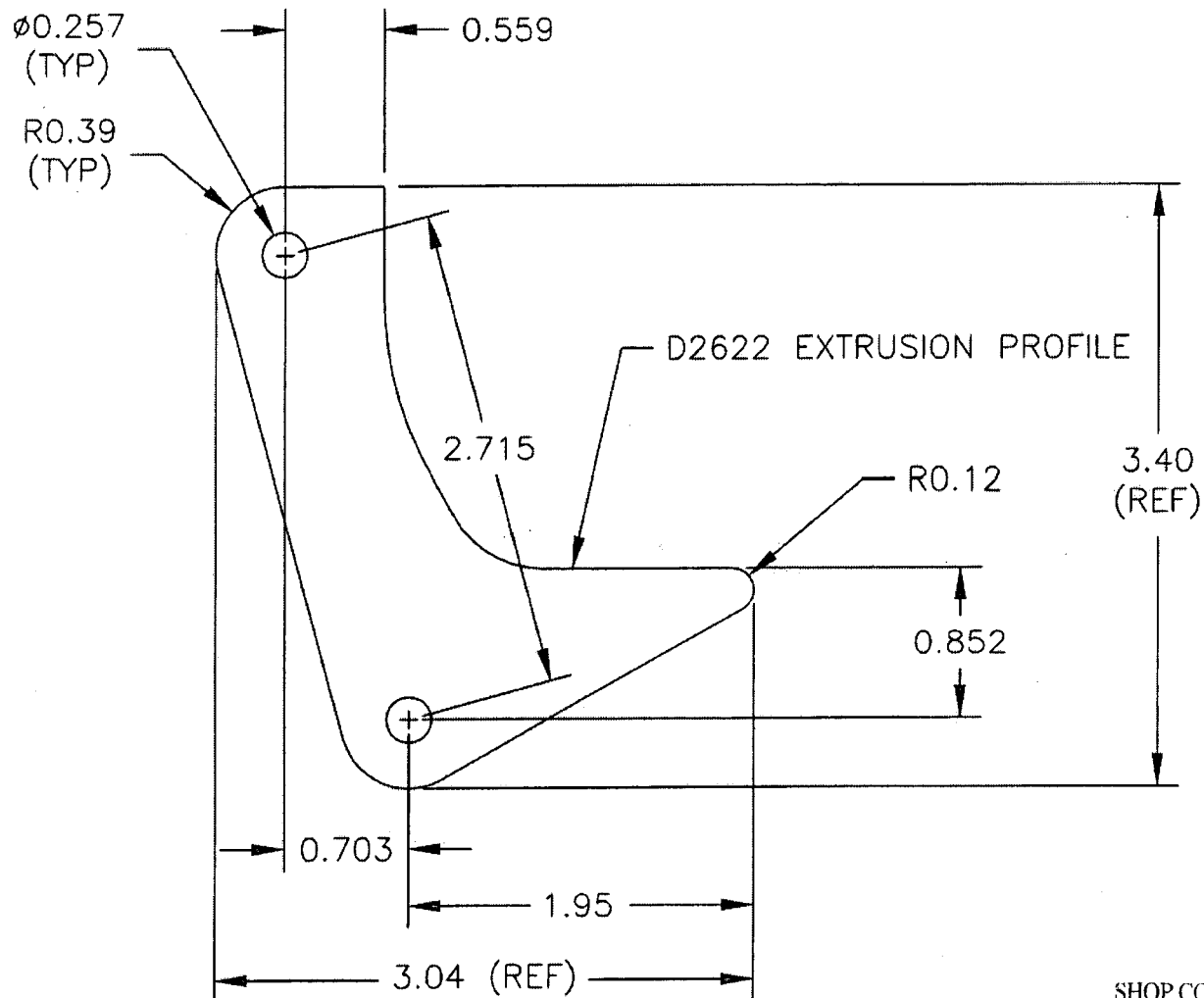
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2944	REV. A SHEET 1 OF 1
DATE 99.12.13		TITLE STEP MOUNTING PLATE	SCALE 1:1
A	99.12.13	NEW ISSUE	

RELEASED
99.12.21 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29351

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK
BREAK ALL SHARP EDGES 0.010 TO 0.020 MAX
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES